



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3262-5

Job Sheet 181574



Part No: D3262-5

Job Qty: 2 ea

Part Name: Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/1/18

Job Tracking No:

Due Date: 8/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F SHEET 5 IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP Rev:B as per ECN10-571 DD 10.05.10 verified :EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/13/18	8/13/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	2 pcs	8/13/18	8/13/18	0.00	0.07	Bandsaw1		DAS 18/08/18
110	CNC Vertical Machining	2 pcs	8/13/18	8/13/18	0.21	2.08	HAAS1-3		52 18/08/18
120	QC	2 pcs	8/13/18	8/13/18	0.00	0.00	QC2 Machining-2		9-89 18/08/18
130	QC	2 pcs	8/13/18	8/13/18	0.00	0.00	QC8 Machining-2		9-89 18/08/18
140	Packaging	2 pcs	8/13/18	8/13/18	0.00	0.00	Packaging3-1		WAG03 18/08/18
150	QC21-SA	2 Ea	8/13/18	8/13/18	0.00	0.00	QC21		AUG 15 2018

Part Op 100 - Cut blanks: 6.000" x 0.500" x 5.400" long Bar

Descriptions: 110 - Machine as per dwg D3262 Machine as per Folio FA902 and Dwg D3262 TAP USING JIG DT9636

140 - LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X06.000	6061-T6 Bar .500 X 6.00	1.9200 ft (.96 ea) 0.9 045	90-Start up Operation	5033404 5099316

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X06.000	2	43	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
DART Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K94 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com Container No: S099317 Part: D3262-5 Job No: 181574 Serial No/Batch: S099317 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 06/05/18			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Marks/Chatter ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : _____																					

DART AEROSPACE LTD		Work Order:	181574
Description: Cap		Part Number:	D3262-5
Inspection Dwg: D3262 Rev: F		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	0.449	✓		Ver	
0.25	+/-0.030	0.250	✓		Ver	
Ø0.875	+/-0.010	Ø0.875	✓		Ver	
Ø5.005	+0.010/-0.000	Ø5.007	✓		Ver	
R0.063	+/-0.010	R0.063	✓		R.G.	
0.080	+/-0.010	0.080	✓		Ver	
0.13	+/-0.030	0.13	✓		Ver	
0.070 x 45°	+/-0.010 x 0.5°	0.070 x 45°	✓		Ver	
Ø5.165 Ref	+/-0.010	Ø5.166	✓		Ver	
1.63	+/-0.030	1.625	✓		H.G.	
3.25 Ref	+/-0.030	3.24	✓		H.G.	
9/16-18 UNF-3B	N/A	9/16-18	✓		T.G.	
3/4-16 UNF-3B	N/A	3/4-16	✓		T.G.	
0.091	+0.007/-0.008	0.091	✓		Ver	
R0.03	+/-0.010	R0.03	✓		Tool	
R0.02	+0.00/-0.01	R0.02	✓		Tool	
45°	+/-0.5°	45°	✓		Tool	
30°	+/-0.5°	30°	✓		Tool	
Ø0.588	+0.005/-0.000	Ø0.589	✓		Ver	
Ø0.696	+0.007/-0.008	Ø0.695	✓		Ver	
0.101	+0.008/-0.007	0.103	✓		Ver	
R0.03	+/-0.010	R0.03	✓		Tool	
R0.02	+0.00/-0.01	R0.02	✓		Tool	
45°	+/-0.5°	45°	✓		Tool	
30°	+/-0.5°	30°	✓		Tool	
Ø0.771	+0.005/-0.000	Ø0.773	✓		Ver	
Ø0.882	+0.008/-0.007	Ø0.882			Ver	
DAS 52						

Measured by:	9-89	Checked by:	[Signature]	QC Inspector:	
Date:	18/08/05	Date:	18/08/05	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ/DD	[Signature]
B	17.02.16	Dwg Rev updated	KJ	[Signature]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				